



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4785-041
Job Sheet 167236



Part No: D4785-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, LH/RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 11/30/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

PDD 167236

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/28/17	0.00	0.00	Start Up Large Fab2		<i>17-11-20</i>
100	Large Fab	1 pcs		11/29/17	0.00	25.00	Large Fab 1		<i>17-11-18</i>
110	QC	1 pcs		11/29/17	0.00	0.00	QC9		<i>17-11-21</i>
120	QC	1 pcs		11/29/17	0.00	0.00	QC5		<i>17-11-21</i>
125	HandFinish	1 pcs		11/29/17	0.00	0.52	HandFinish2		<i>17-11-22</i>
130	Powdercoat	1 pcs		11/29/17	0.00	0.84	Powdercoat2		<i>17-11-23</i>
140	QC	1 pcs		11/29/17	0.00	0.00	QC3		<i>17-11-23</i>
150	HandFinish	1 pcs		11/30/17	0.00	0.52	HandFinish4		<i>17-11-23</i>
160	QC	1 pcs		11/30/17	0.00	0.00	QC5		<i>38</i>
170	Packaging	1 pcs		11/30/17	0.00	0.00	Packaging3		<i>17-11-23</i>
180	QC21-SA	1 Ea		11/30/17	0.00	0.00	QC21		<i>NOV 30 2017</i>

Part Op 100 - 1- Use DT9610A to assemble contour ribs and the (2) D3916-5 ribs , weld as per dwg D4785 ***ENSURE BOTTOM Descriptions: OF BASE RIB ARE STRAIGHT*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D4785 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends ***USE DT10158 WITH SHIM WHEN WELDING BOTTOM OF RIB D4785-115*** 3- weld hinge (3) and Mounting brackets as per dwg D4785
110 - ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT*** Use DT10160 jig to ensure D4785-115 holes are align after welding
120 - ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT***
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick kit and assemble

M 138487 START: 2:55 O.V.T: 3:50 FINISH: 3:10.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	<i>5005842</i> D2581 <i>F165913</i>	2	18	0	0
	<i>5002297</i> D3913-1	1	16	0	0
	<i>5002297</i> D3913-3 <i>002108</i>	1	18	0	0
	<i>5002297</i> D3913-9	1	1	0	0
	<i>5002297</i> D3916-5 <i>F165913</i>	2	13	0	0
	<i>5009181</i> D4016-1	3	10	0	0
	<i>5005857</i> D4017-7 <i>F165913</i>	3	18	0	0
	<i>5005857</i> D4020-11	2	0	0	0
	<i>5005857</i> D4021-5	2	18	0	0
	<i>5005857</i> D4034-041	1	1	0	0
	<i>5005857</i> D4034-043	1	1	0	0
	<i>5005857</i> D4785-1	2	2	0	0
	<i>5005857</i> D4785-115	4	4	0	0
	<i>5006051</i> D4785-117	2	0	0	0
	<i>5006051</i> D4785-3	2	2	0	0

\$75 -

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

150-HandFinish

D4785-5	F155450	3	9	0	0
D4793-1	144943	3	4	0	0
D4793-3	144255	1	3	0	0
M304EX0.75-16F	8001737	33	670	0	0
AN3-10A	5013206	6	256	0	0
D2931	5013207	2	1,336	0	0
D4672-1	5005866	2	5	0	0
MS20600-AD4W3	5013208	2	319	0	0
MS21042L3	5013209	6	862	0	0
NAS1149DN832J	5013210	2	1,752	0	0
NAS1149F0332P	5013211	12	3,231	0	0

Part Specifications

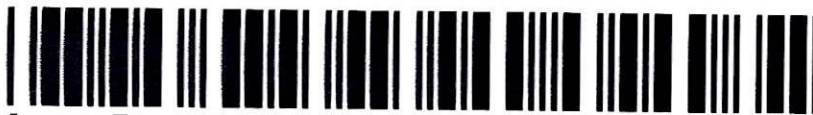
Specifications could not be found.

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DART
AEROSPACE
S011626

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Long Basket Base Assembly, LH/RH

PART NO: D4785-041

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/20/17

Job No: 167236

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					